Work Order ID   101212

Monday, May 06, 2013 10:56:28 AM

101212 ASAP.

Item ID:	D3238-3	Accept
Revision ID:		
Item Name:	Plate	

N9000401nn Setup Start *NS1*
Stop *NS2*

Start Date:	5/6/2013	Start Qty: 4.00	*4*	Cust Item ID:
Required Date: 5/9/2013		Req'd Qty: 4.00	*4*	Customer:
Reference:				

Approvals: Process Plan: mf Date: 13-5-6 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3238	Rev C								
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET	0.00							
	Memo	0.00							
	CUT BLANK FILE IN D32382-Deburr if necessary								
110 *110* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE	0.00							
	Memo	0.00							
	MILL SERRATIONS AS PER DWG D3238 USING DT8934								
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIR	0.00							
	Memo	0.00							

N/A
blanks already cut

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved										

FAULT CATEGORY

Landing Gear

☐	Bending		
☐	Centre Not Concentric to O/S		
☐	Cracks		
☐	Crushed/Crimped		
☐	Cuffs		
☐	Heat Treat		
☐	Inspection Strip in Tube		
☐	Ripples in Bend		
☐	Torque Waves in Extrusion		
☐	Turning Sequence		
☐	Wave/Twist in Tube		

General

☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Drill Holes	☐ Offset		
☐ Drawing	☐ Out of Calibration	_____	
☐ Finish	☐ Out of Sequence	_____	
☐ Folio	☐ Outside Dimensions	_____	

Work Order ID   101212

Monday, May 06, 2013 10:56:28 AM

101212

Item ID:	D3238-3
Revision ID:	
Item Name:	Plate

Accept   ***N900040100***

Start Date:	5/6/2013	Start Qty:	4.00
Required Date:	5/9/2013	Req'd Qty:	4.00

4
4

Cust Item ID:
Customer:

Reference:

Setup	Start ***NS1***
	Stop ***NS2***
Run	Start ***NR1***
	Stop ***NR2***

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N):   Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 ***130*** Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Dwg D3238 Dwg Rev: _C_ Prog Rev: _C_ 2- Deburr if necessary	0.00 0.00				9	0		JMB-5-8
140 ***140*** QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				9	0		JMB-5-8
150 ***150*** QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				9			

DAS 27

BS8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
NCR No. _____	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Work Order ID   101212

Monday, May 06, 2013 10:56:28 AM

101212

| | | Accept | ***N9000401OO*** | Setup | Start | ***NS1*** |

Item ID: D3238-3

Revision ID:

Item Name: Plate   Stop   ***NS2***

Start Date: 5/6/2013   Start Qty: 4.00   *4*   Cust Item ID:

Required Date: 5/9/2013   Req'd Qty: 4.00   *4*   Customer:

Reference:

| | | | | | Run | Start | ***NR1*** |

Approvals: Process Plan: Date: Tooling: Date:

                       QC: Date: SPC (Y/N):   Date: Stop   ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 ***160*** HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				9.	7H6	13	5-8
170 ***170*** QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	DAS 27 13 S. 8			9.			
180 ***180*** Packaging Packaging	Identify as per dwg & Stock Location: 634 Memo	0.00 0.00				9x			13-5-8

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. _____	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

_____
_____
_____

Monday, May 06, 2013 10:56:28 AM

Item ID: D3238-3   Accept   *N9000040100*   Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Plate

Start Date: 5/6/2013   Start Qty: 4.00   *4*   Cust Item ID:
Required Date: 5/9/2013   Req'd Qty: 4.00   *4*   Customer:
Reference:

                                                                      Run   Start *NR1*
Approvals: Process Plan: Date: Tooling: Date: Stop *NR2*
                 QC: Date: SPC (Y/N):   Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC Quality Control	Memo	0.00							

MW 13-05-08

MW

13-5-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other
_____
_____
_____

Work Order ID:	101212											
Parent Item:	D3238-3					Start Date: 5/6/2013			Required Date: 5/9/2013			
Parent Item Name:	Plate					Start Qty: 4.00			Required Qty: 4.00			

Comments: IPP Rev:A   New Issue   06-10-20   EC

Component Item ID/ Item Name	Replacement Item iD	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
~~AI2024T3S.080~~ ~~2024-T3 .080 sheet~~		Purchased	No		.	100	sf	28.0000	0.012	~~0.0505263~~			

JM13-S-8

	Location	Loc Qty	Loc Code
	MAT022	28	
	123217	28	

Already Machined β# 119117   0.25 S.F.

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

A	03.11.25	NEW ISSUE
B	07.01.17	ADD −21/−23/−25/−31/−33/−35; CHANGE −11/−13/−15 TO 6061−T6
C	07.02.19	ADD 5052−H32 OPTION

RELEASED
07.02.20

D3238−1 PLATE (SHOWN)
D3238−11 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

2.00
1.328
0.075
0.34
0.36
0.73

SEE DETAIL A

Ø0.203
(TYP 2 PLACES)

1.50
0.820
0.34
0.34
0.075
0.320
1.00

Ø0.203
(TYP 4 PLACES)

SEE DETAIL A
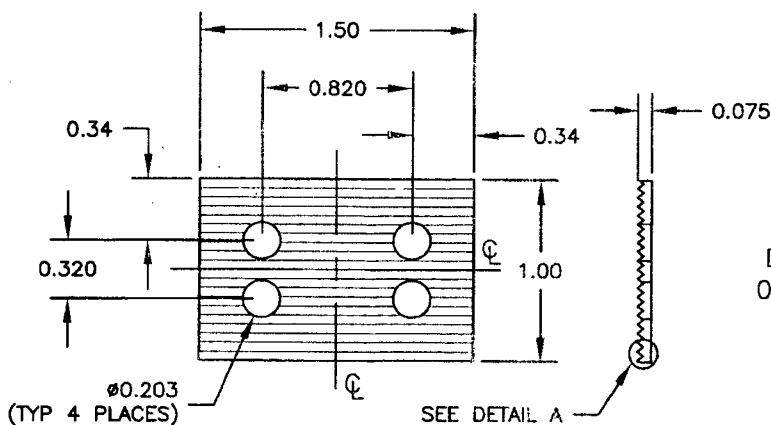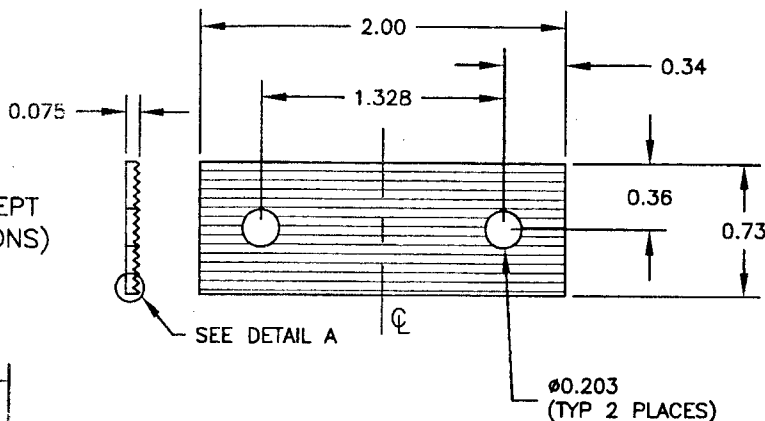
D3238−3 PLATE (SHOWN)
D3238−13 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

NOTES:
1) MATERIAL −1/−3/−5/−21/−23/−25 PLATE:
      ALUMINUM 2024−T3 SHEET PER QQ−A−250/4 OR AMS 4037
      (REF DART SPEC M2024T3S)
    −11/−13/−15/−31/−33/−35 PLATE:
      ALUMINUM 6061−T6/−T62 SHEET, 0.020 THICK, PER QQ−A−250/11 OR
      AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
      OR
      ALUMINUM 5052−H32 SHEET, 0.020 THICK, PER QQ−A−250/8 OR
      AMS 4016 (REF DART SPEC M5052H32S.020)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) SEE SHEET 3 FOR DETAIL A
7) PARTS ARE SYMMETRIC ABOUT ℄

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: _____   Date: _____

	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
Work Order: _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

DESIGN	DRAWN BY	DART AEROSPACE LTD
	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3238	SHEET 2 OF 3
DATE		TITLE	SCALE
07.02.19		PLATE	1:1

1.75
1.030
0.36

Ø0.203
(TYP 2 PLACES)

0.35
0.70

SEE DETAIL A

0.075

RELEASED
07.02.20

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

1.96
1.300
0.650

0.33

R0.25
(TYP)

0.075

0.40

0.65

1.75   0.950

Ø0.203
(TYP 3 PLACES)

0.80

SEE DETAIL A
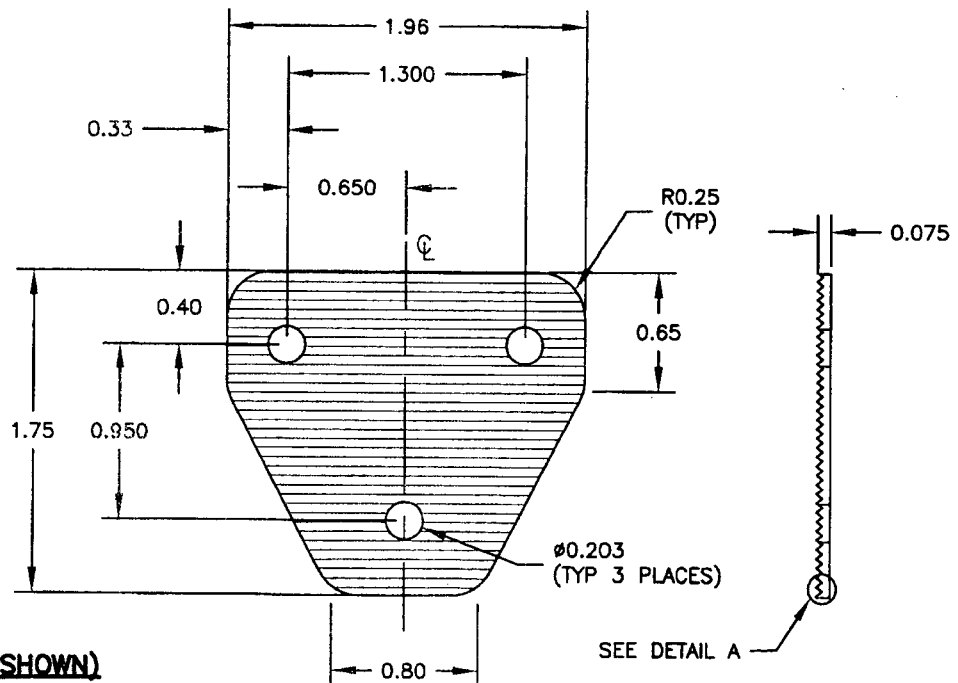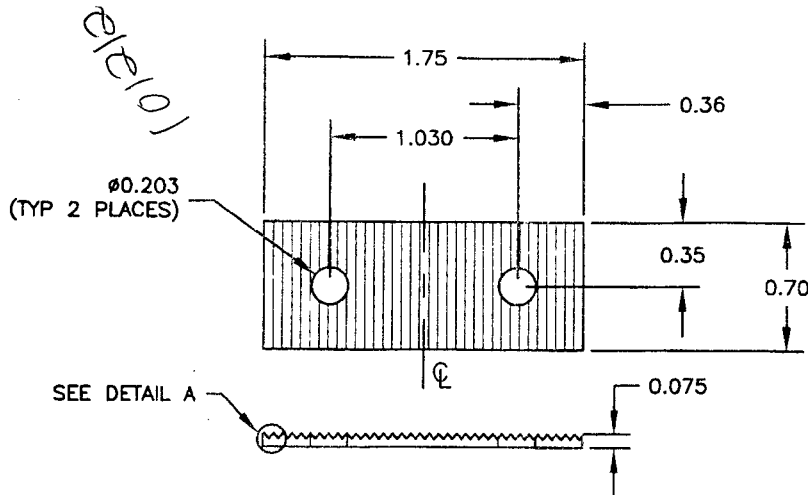
D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: Date:

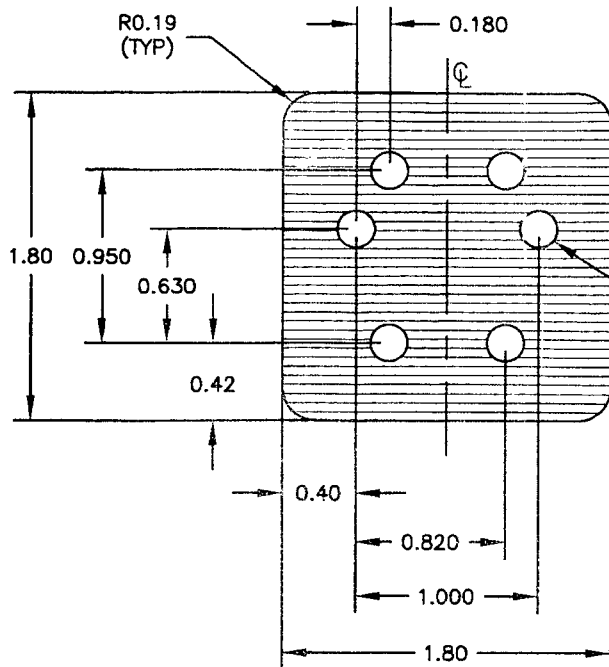| Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

R0.19
(TYP)

0.180

Ø0.203
(TYP 6 PLACES)

1.80   0.950

0.630

0.42

0.40

0.820

1.000

1.80

0.075

SEE DETAIL A

RELEASED
07.02.20

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

0.025 (TYP)

0.050
(TYP)

0.032

0.075
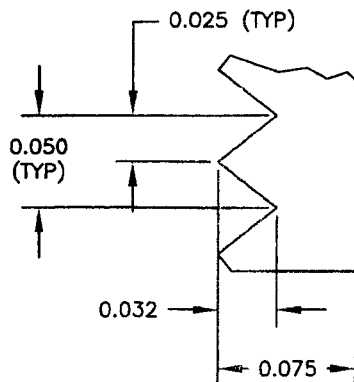
DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1

1.63

1.030

0.515

0.30

R0.30
(2 PLACES)

Ø0.203
(TYP 2 PLACES)

0.30

0.830   1.43

0.250

R0.25
(2 PLACES)

Ø0.203

1.11
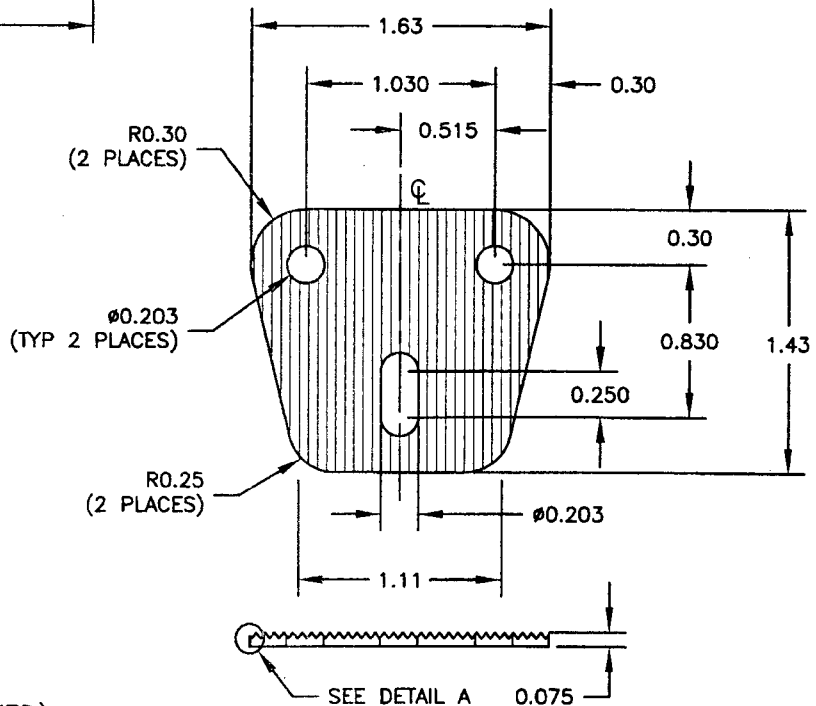
SEE DETAIL A   0.075

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled

- ☐ Other

_____

_____

_____

DART AEROSPACE LTD		Work Order: 10218
Description: Plate		Part Number: D3238-3
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	+/-0.030	1.501"	—		V	Jkmo7
1.00	+/-0.030	1.000"	—		V	
0.34	+/-0.030	0.340"	—		V	
0.34	+/-0.030	0.342"	—		V	
0.820	+/-0.010	0.822"	—		V	
Ø0.203	+0.005/-0.001	0.205"	—		V	
0.320	+/-0.010	0.323"	—		V	

Measured by: Jm	Audited by:	Prototype Approval:	N/A
Date: 13-5-8	Date: 13-5	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.02.23	Dwg Rev. updated	KJ/JLM	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
NCR No. _____	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		_____